

Work Order ID 67739

Tuesday, March 29, 2011 2:30:26 PM



Page 1

Item ID:	D3508-7	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearplate					
Start Date:	3/29/2011	Start Qty: 6.00		Cust Item ID:		
Required Date:	4/8/2011	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>H</u>	Date:	<u>11-03-30</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3508	Rev C

100		0.00							
	FLOW WATER JET								
Waterjet		0.00							
FLOW CNC Waterjet	Memo								
<u>304 - 040</u>	1-Cut as per Dwg D3508 <input type="checkbox"/> Dwg Rev: <u>C</u> <input type="checkbox"/> Prog Rev: <u>C</u> <input type="checkbox"/> 2- Deburr if necessary								

B11-4-4

(6)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo								

B11-4-4

120		0.00							
	QC8- Inspect parts - second check								
QC		0.00							
Quality Control	Memo								

Siclog/05

(6)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67739

Tuesday, March 29, 2011 2:30:27 PM



Page 2

Item ID: D3508-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/29/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



NC BRAKE

6

Brake NC

Memo

0.00

Brake NC

1-Form on brake using DT8326 and DT8261 as per Dwg D3508

SB 11/04/05

140

0.00



QC5- Inspect part completeness to step on W/O

16

QC

Memo

0.00

Quality Control

150

0.00



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M 11/5128.

6 BR 11-4-6.

Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:15

OVEN TEMPERATURE:

320° FINISH TIME:

11:45.

W/O:		WORK ORDER CHANGES						
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Work Order ID 67739

Tuesday, March 29, 2011 2:30:27 PM



Page 3

Item ID: D3508-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/29/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

X6 0 4/10/11

170

Identify as per dwg & Stock Location: FP-21 0.00

Packaging

Memo

0.00

Packaging

6 BL 11-4-6

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/4/11 MFMF
11-04-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 2:30:32 PM

Page 1

Work Order ID: 67739



Parent Item: D3508-7

Parent Item Name: Wearplate

Start Date: 3/29/2011

Required Date: 4/8/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

109.0000

0.3116

1.968



304/316 .040 Sheet



B11-4-4

Location

Loc Qty

Loc Code

MAT020

109

115953

1

116437

44

116623

64

116437

6

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	47739
Description: Wearplate		Part Number:	D3508-7
Inspection Dwg: D3508	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.066	>		V HB02	
2.813	+/-0.010	2.811	>		V	
Ø0.188	+0.005/-0.001	.189	>		V	
0.375	+/-0.010	.375	>		V	
6.875	+/-0.010	6.875	>		T HB01	
13.750	+/-0.010	13.750	>		T	
16.10	+/-0.030	16.10	>		T	
0.300	+/-0.010	.305	>		V	
0.300	+/-0.010	.304	>		V	
0.040	+/-0.010	.036	>		V	

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 11-4-4	Date: 11/04/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.07	New Issue	KJ/EC	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

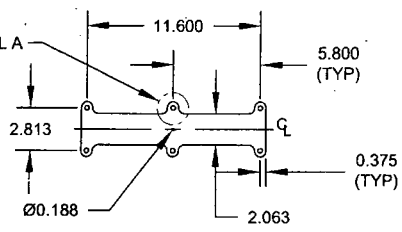
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

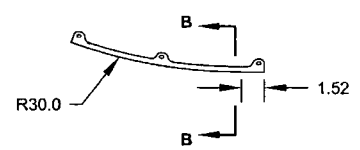
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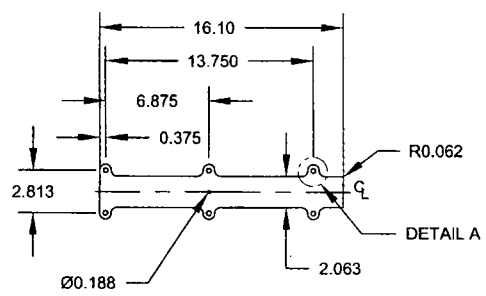
DETAIL A



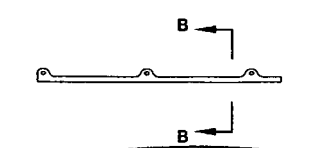
D3508-1 FLAT PATTERN



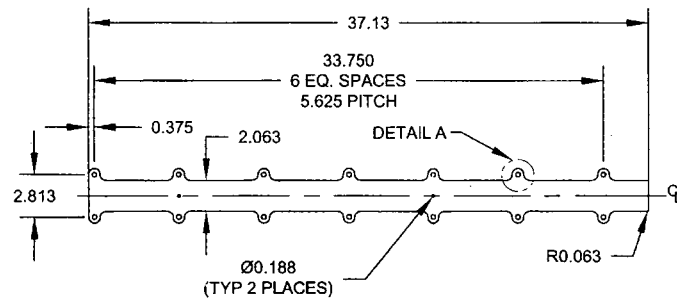
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



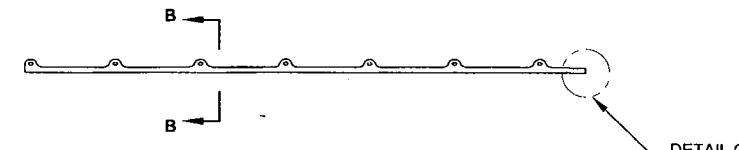
D3508-7F FLAT PATTERN



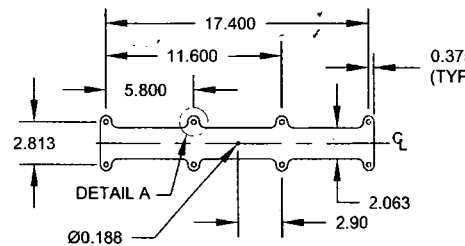
D3508-7F BENDING DETAIL
L (MAKE FROM D3508-7F)



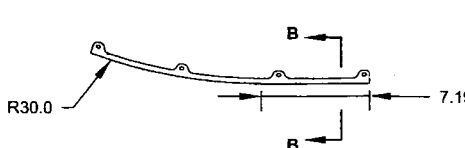
D3508-3 FLAT PATTERN



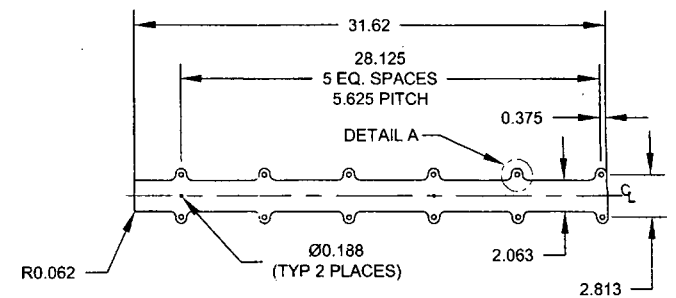
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



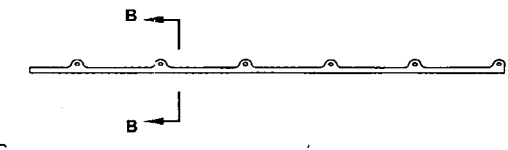
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005 TO 0.015
 - 7) IDENTIFICATION: NONE
 - 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07-11-16

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3508	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47239

11-03-3L

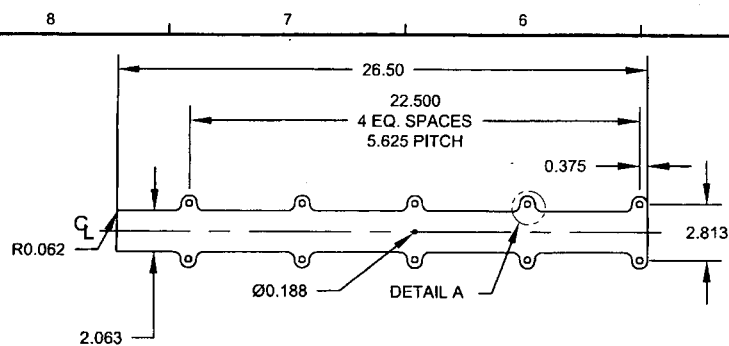
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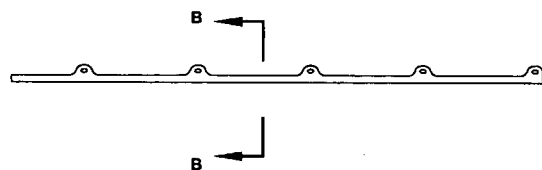
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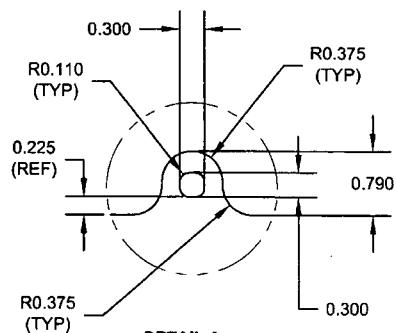
NOTE: Date & initial all entries



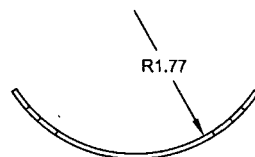
D3508-11F FLAT PATTERN



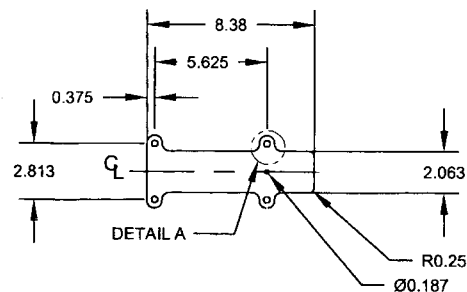
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



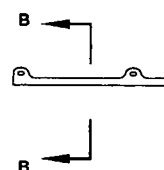
DETAIL A
(SCALE 2:3)



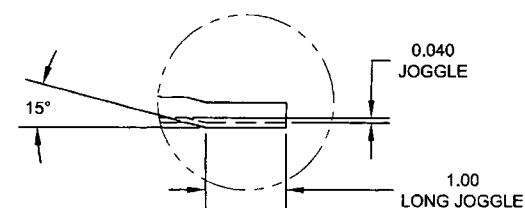
SECTION B-B
(SCALE 2:3)



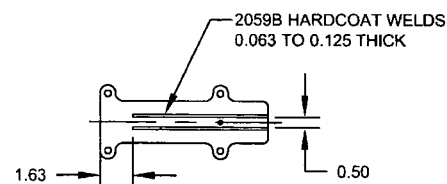
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

u/o 67739

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3508	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:6
DATE	07.04.20	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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